

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010146**Date Inspected:** 19-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of West Tower connection plate weld WD1-SA3-18-89M-1~4-1A. ZPMC welder was identified as 040614. ZPMC QC is identified as Xu Le Feng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3211-TC-U5b-1.

Shielded Metal Arc Welding (SMAW) of West Tower connection plate weld WD1-SA3-18-99M-3-1A and WD1-SA3-18-99M-4-1A. ZPMC welder was identified as 046704. ZPMC QC is identified as Xu Le Feng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3211-TC-U5b-1.

Submerged Arc Welding (SAW) of East Tower Lift 4 Skin Plate B to C corner weld ESTL4-2 B/L-58A. ZPMC welder was identified as 202756. ZPMC QC is identified as Zhan Bo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3211-TC-U5b-1.

Flux Cored Arc Welding (FCAW) of East Tower Lift 4 diaphragm to Skin D weld ESTL4-2-F/L-129, located on the 123 meter double diaphragm top plate. ZPMC welder was identified as 042218. ZPMC QC is identified as Li Hong Fei. The welding appeared to be in conformance with welding procedure specification,

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WPS-B-T-4332-TC-P5-F.

Flux Cored Arc Welding (FCAW) of East Tower Lift 4 diaphragm to Skin D weld ESTL4-2-G/L-130, located on the 127 meter double diaphragm top plate. ZPMC welder was identified as 046706. ZPMC QC is identified as Li Hong Fei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P5-F.

Flux Cored Arc Welding (FCAW) of East Tower Lift 4 diaphragm to Skin D weld ESTL4-2-H/L-61, located on the 131 meter double diaphragm bottom plate. ZPMC welder was identified as 040713. ZPMC QC is identified as Li Hong Fei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation occurred between QC and QA this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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